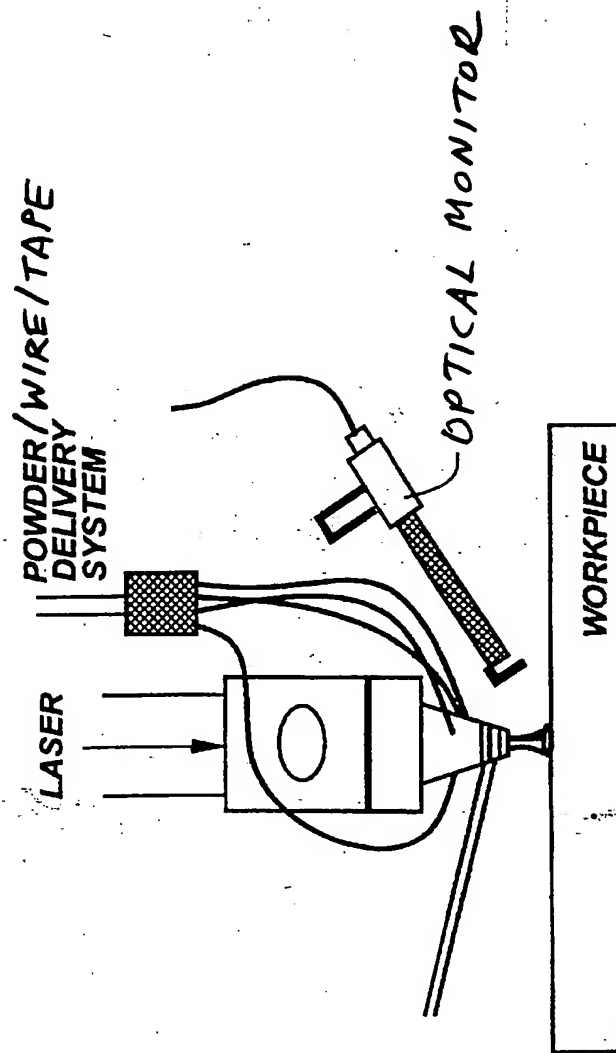


Figure - 2



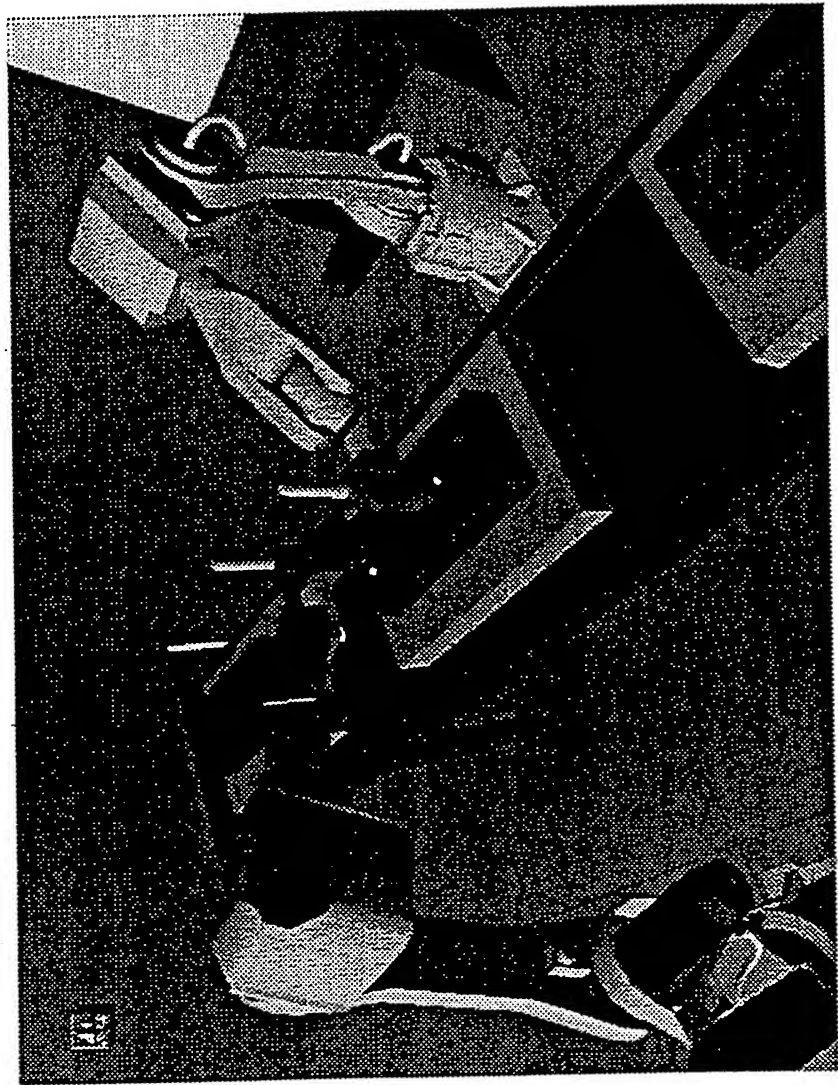


Figure 3. Robotic embodiment of DMD

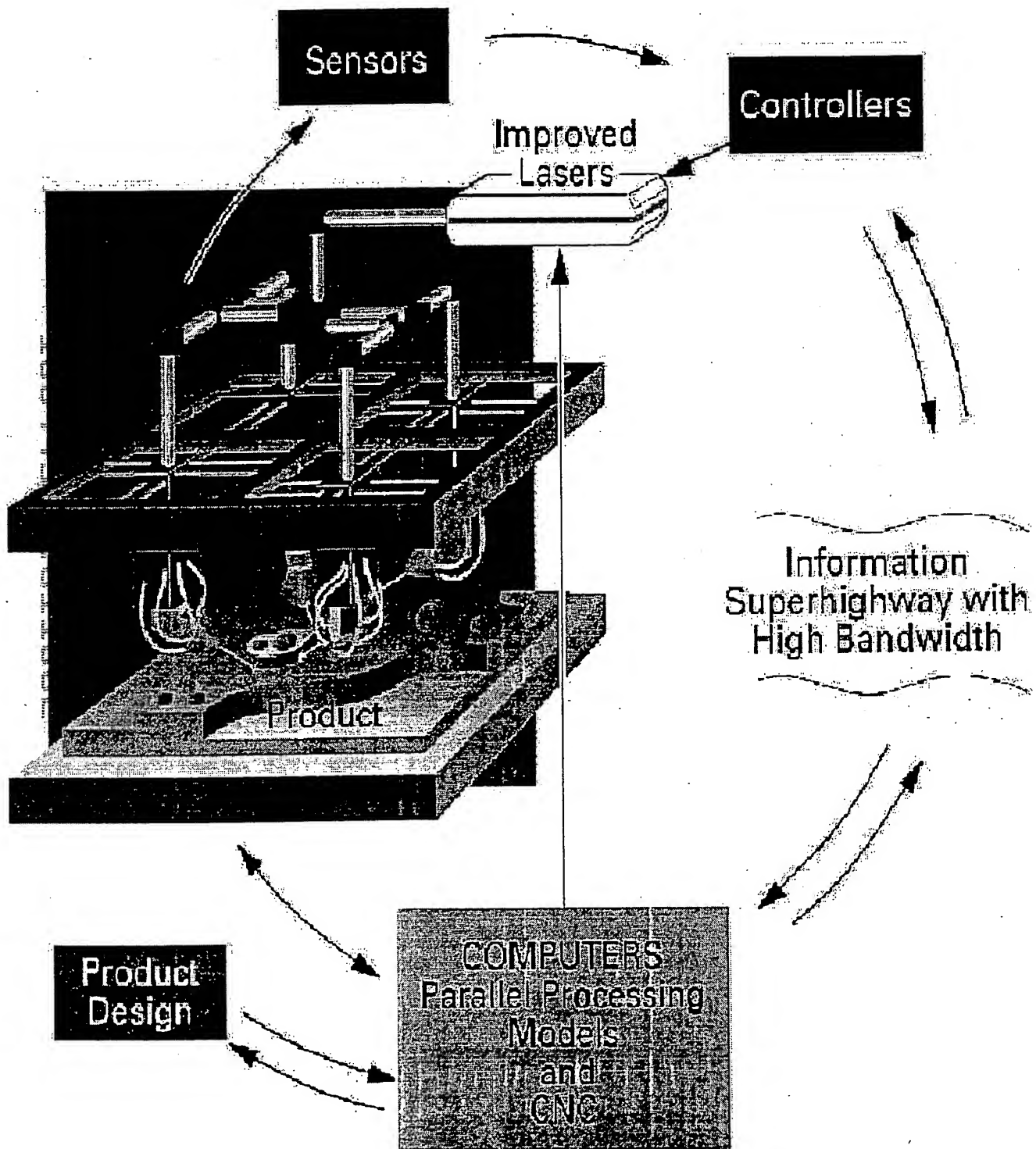


FIGURE 4

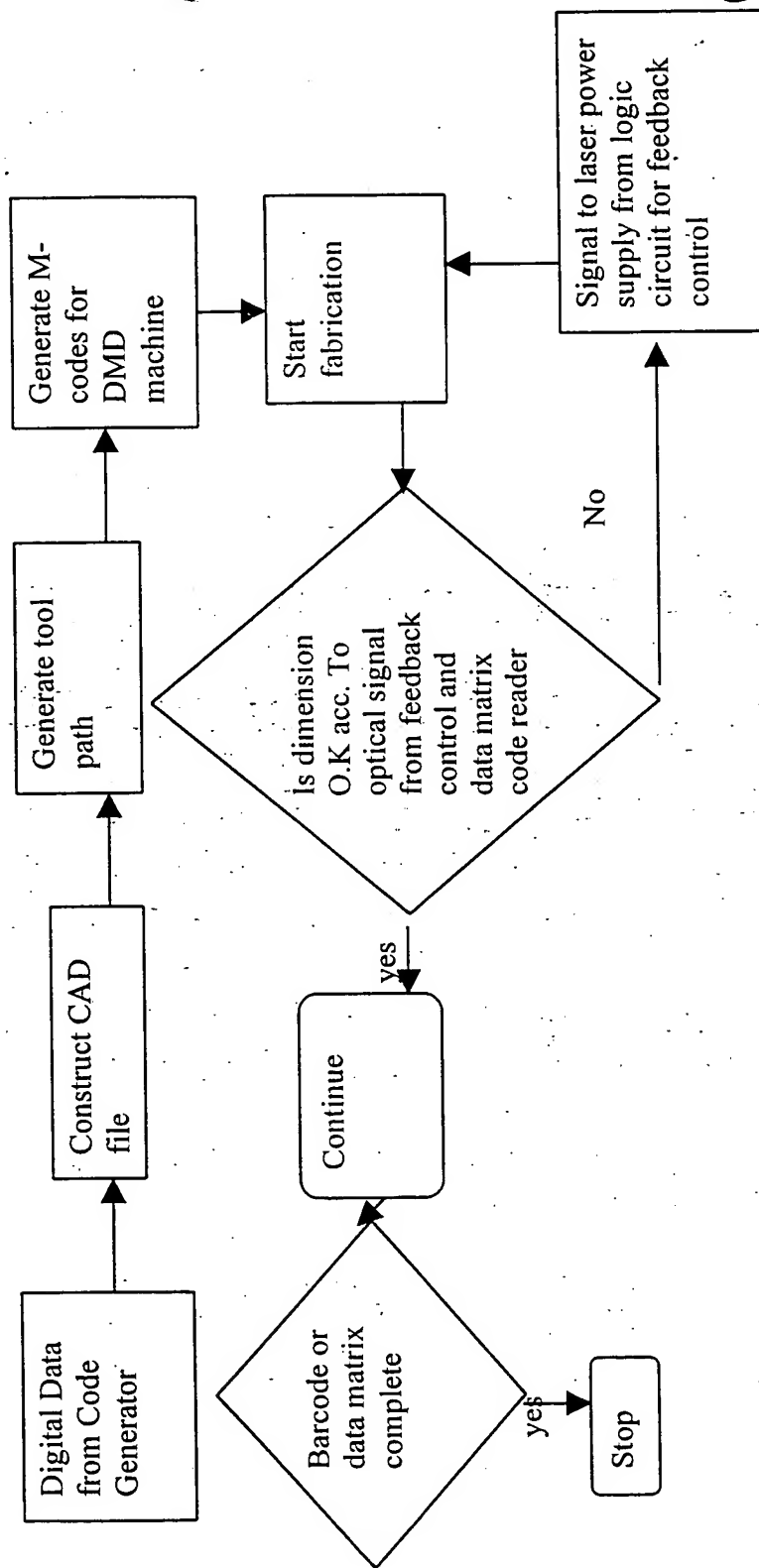


FIGURE 5

10044331 011000

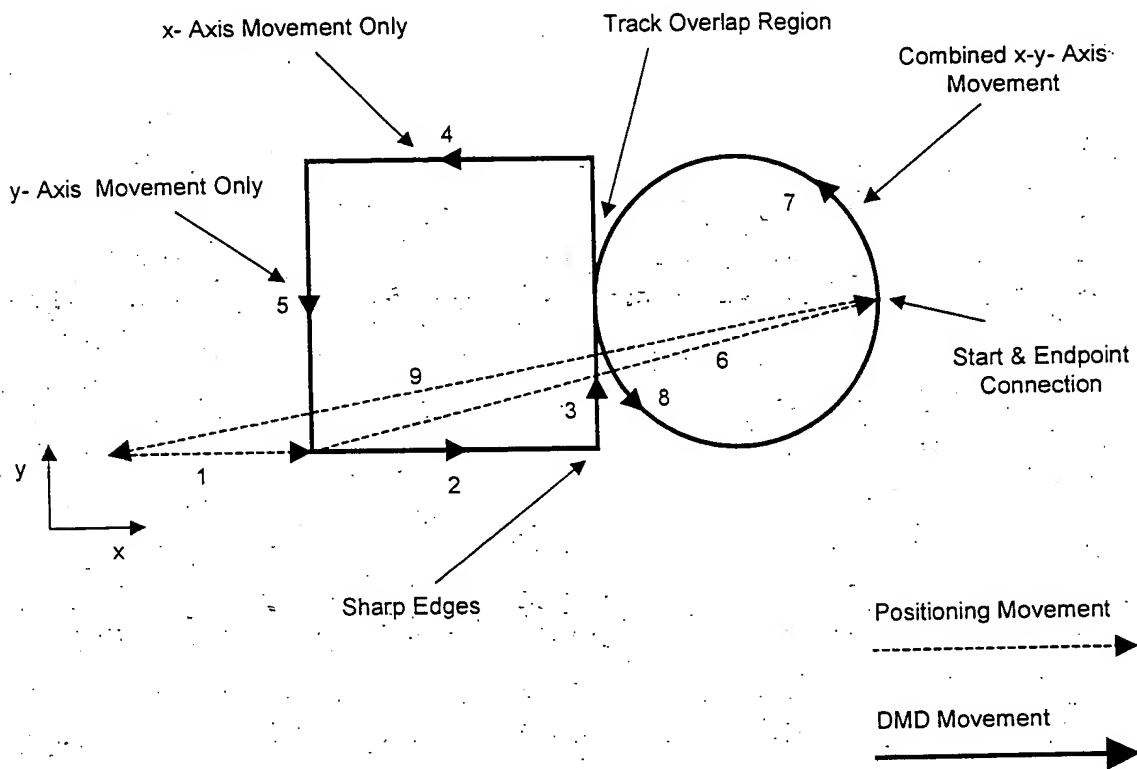
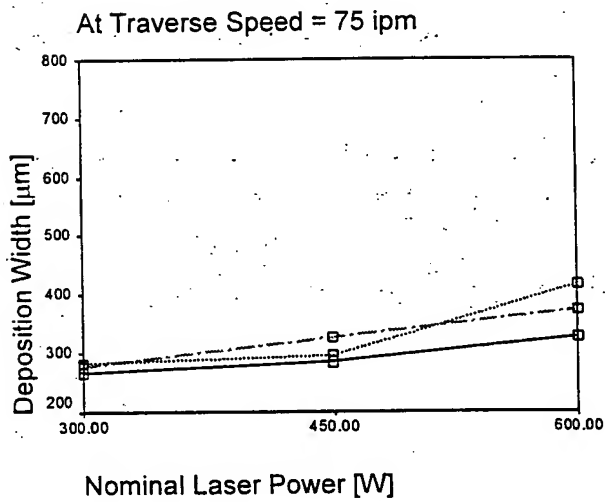
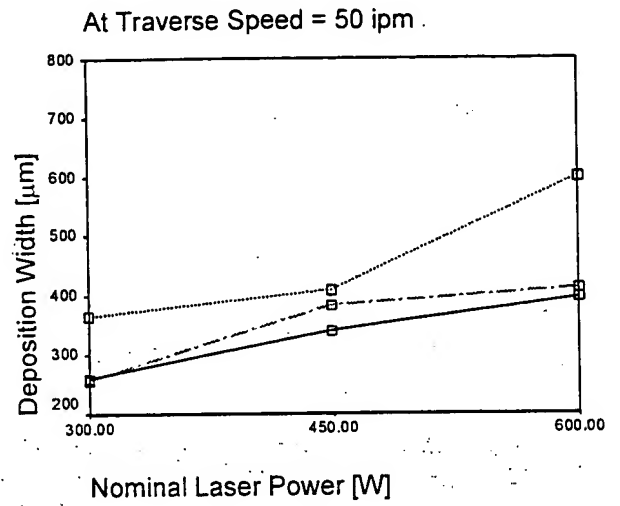
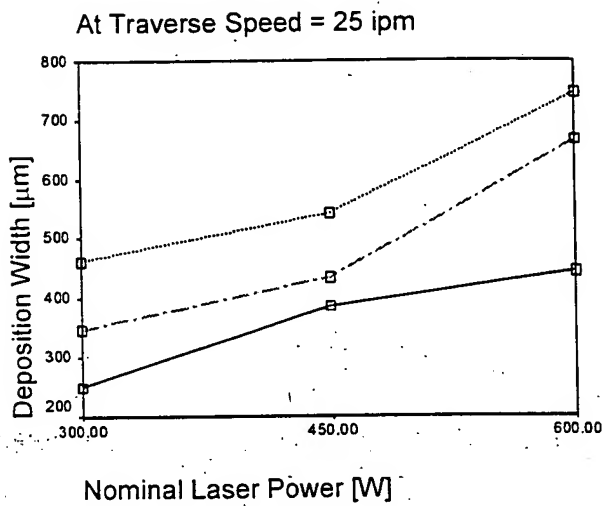


FIGURE 6

20070707



Powder Feed Rate [g/30s]

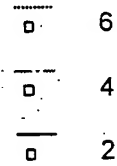
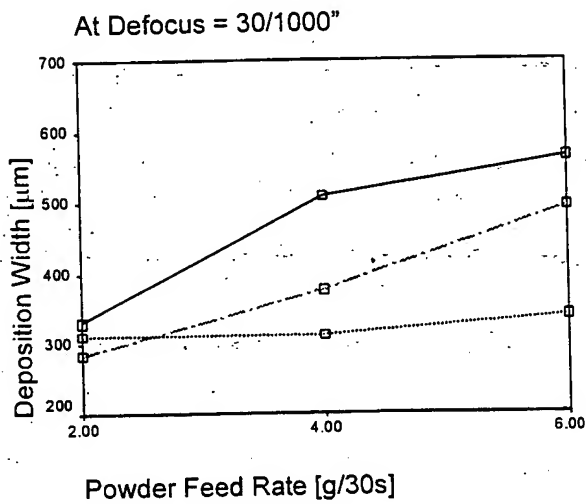
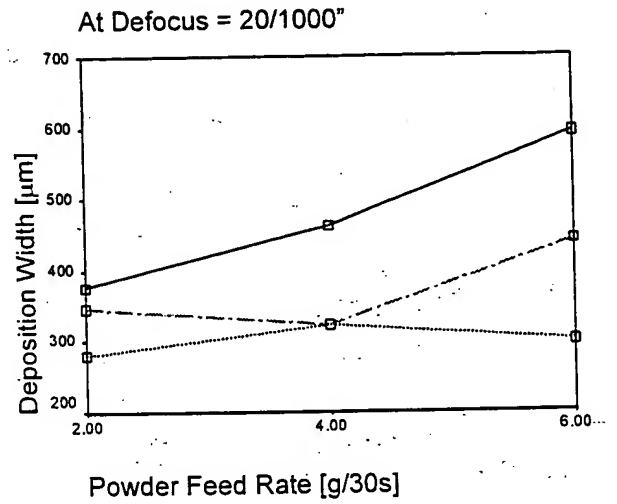
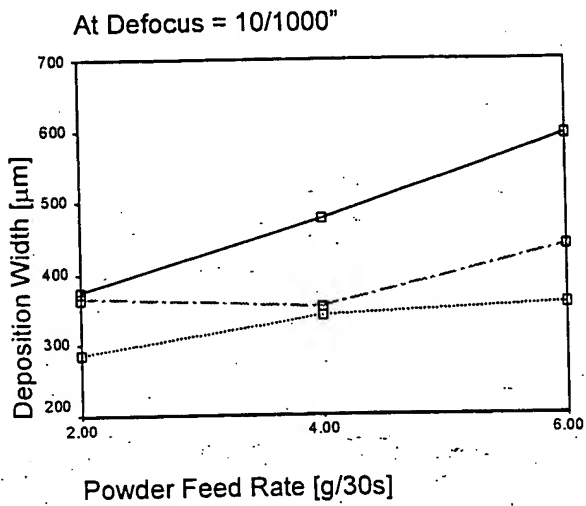


FIGURE 7

2007-10-10 14:44:00

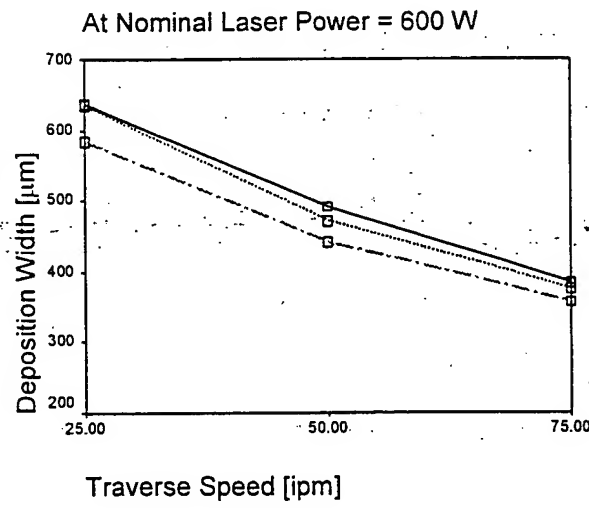
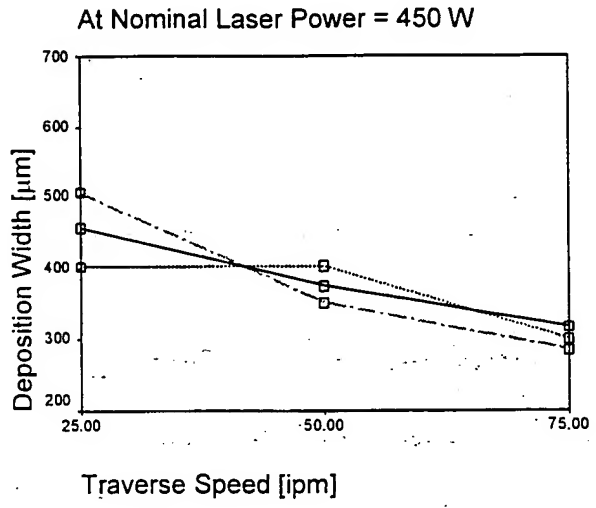
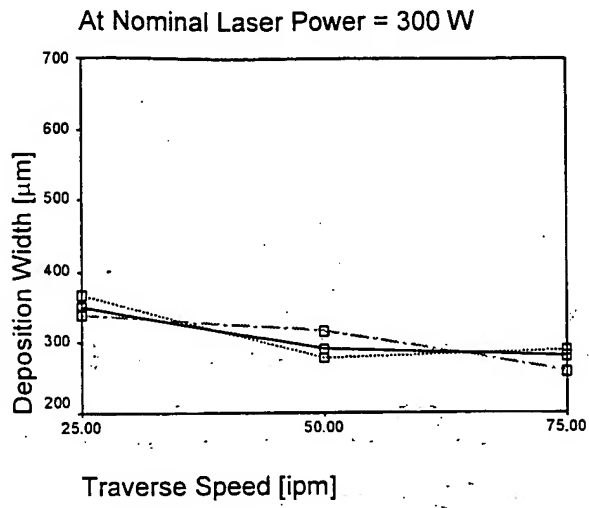


Traverse Speed [ipm]

- 75
- - - 50
- 25

FIGURE 8

2007-07-10 14:00:00

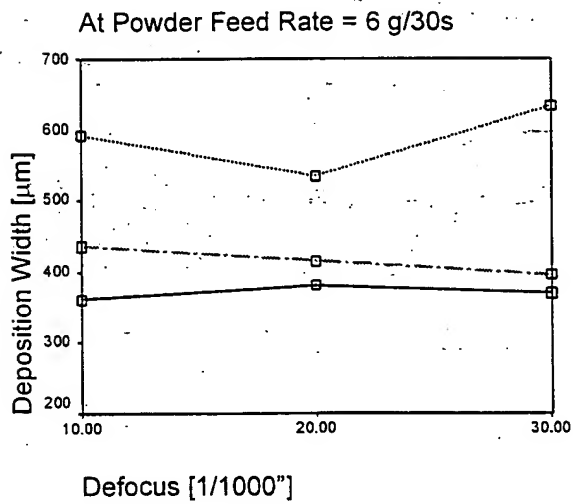
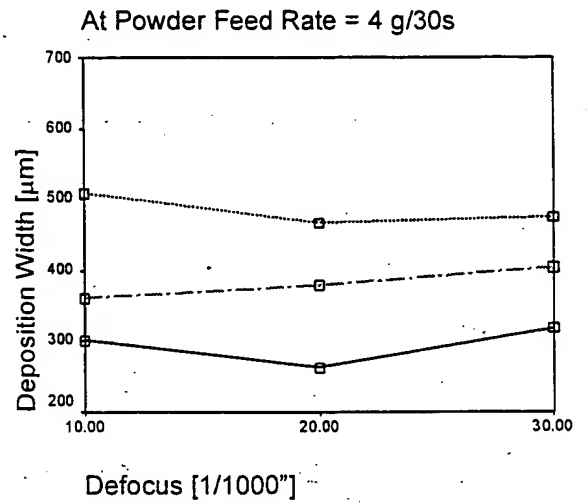
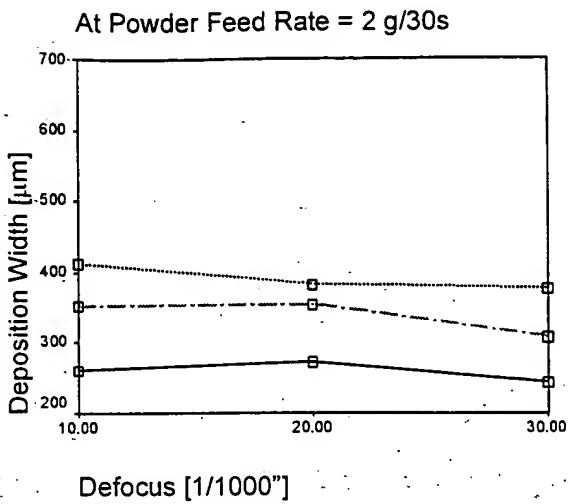


Defocus [1/1000"]

- 30
- 20
- 10

FIGURE 9

COOTED FEEDHOD



Nominal Laser Power [W]

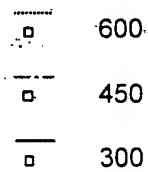
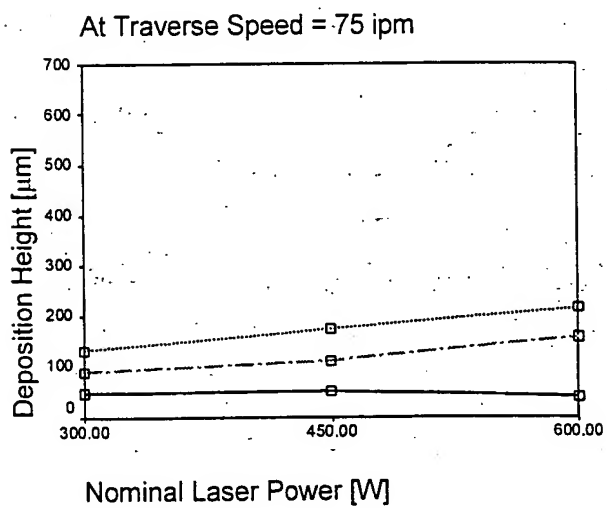
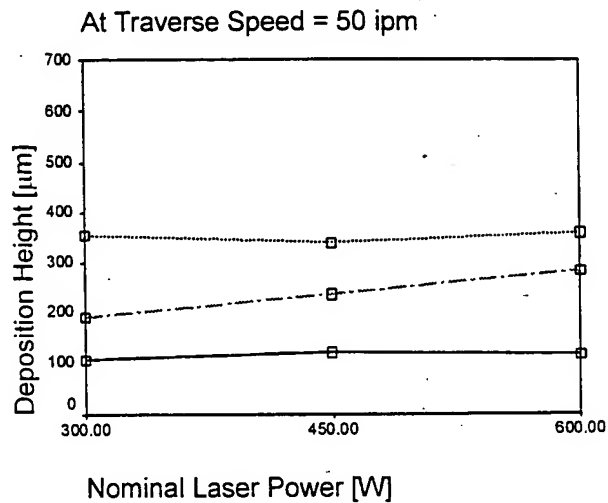
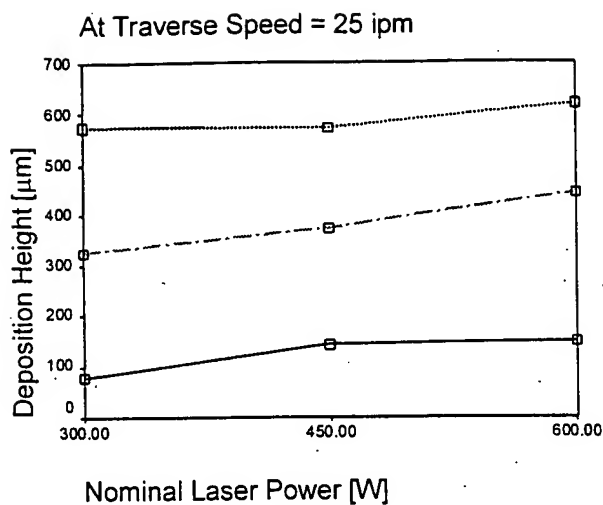


FIGURE 10



Powder Feed Rate

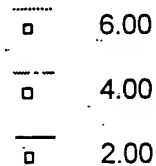
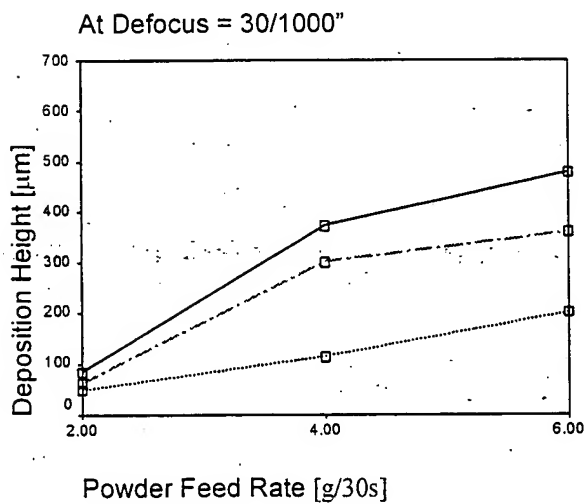
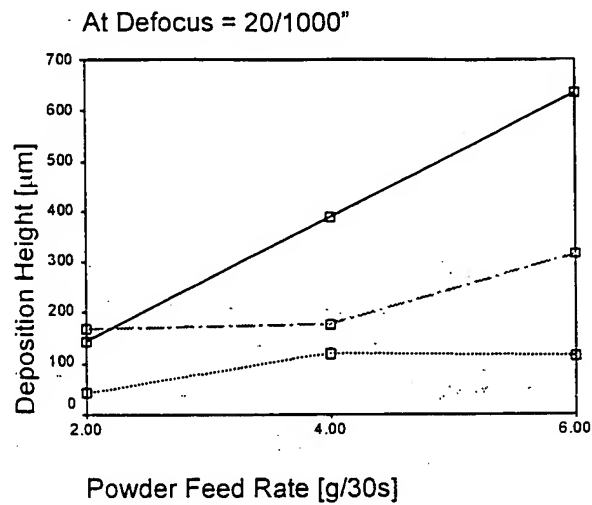
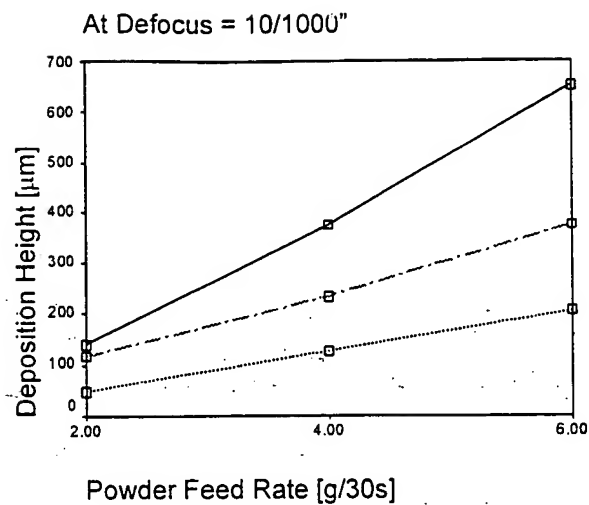


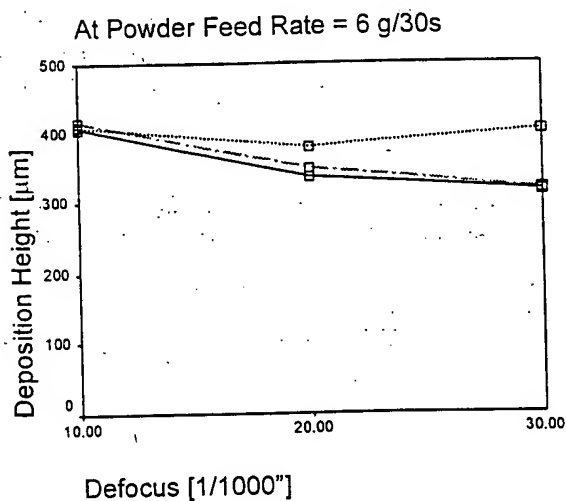
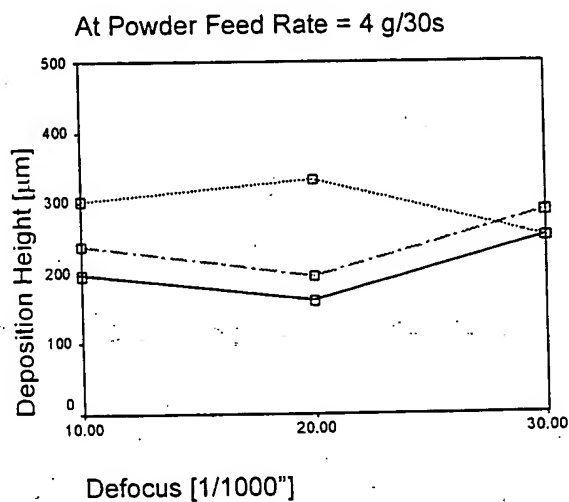
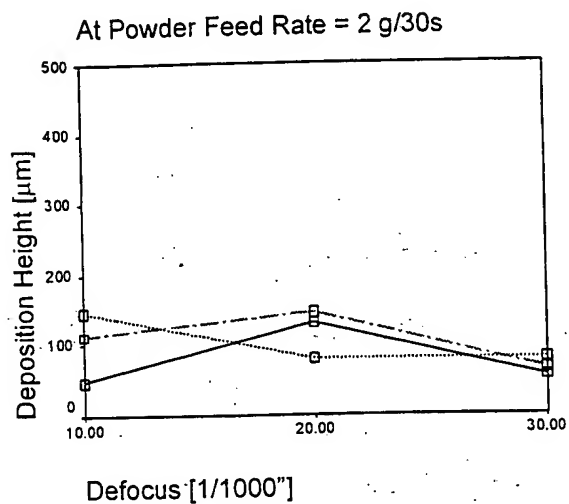
FIGURE 11



Traverse Speed [ipm]

- 75
- 50
- 25

FIGURE 12

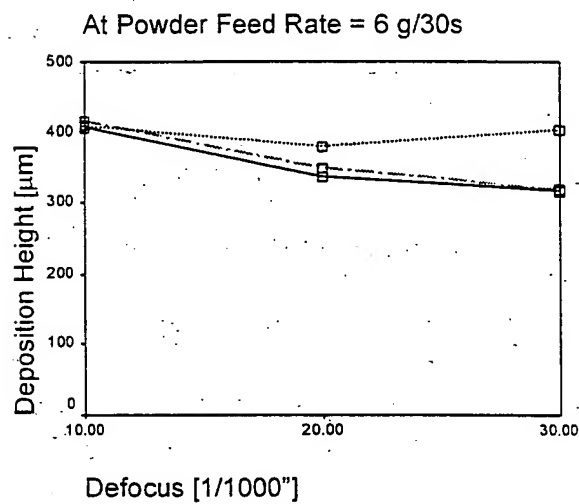
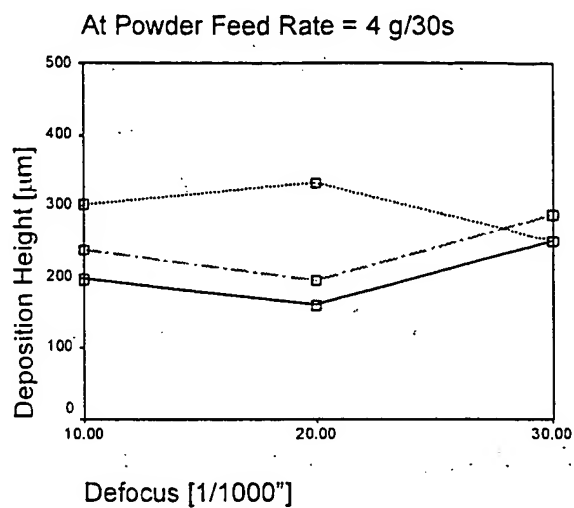
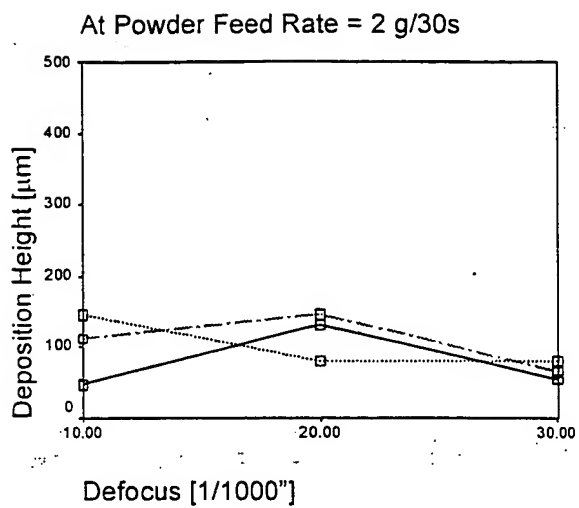


Nominal Laser Power [W]

- 600
- 450
- 300

FIGURE 13

2007-07-07 14:00



Nominal Laser Power [W]

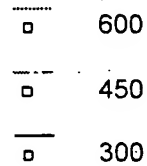


FIGURE 14